

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010563**Date Inspected:** 14-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Le Hong Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

BAY#11:-

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Skirt Plate. The weld designations reviewed are as follows:-

Skirt Plate:-

ESD1-A65B/B-1-10,11,16,17,23,37

ESD1-A65B/B-2-10,15,17,20,37

ESD1-A65B/B-3-8,9,15,16,19,23

ESD1-A65B/B-4-10,12,17,23,37

ESD1-A65B/B-5-10,15,16,17,20,23

ESD1-A65B/B-6-10,15,16,17,23,37

ESD1-A65B/B-7-15,16,20,28,31,38

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The Caltrans Quality Assurance (QA) Inspector performed a random visual weld inspection and observed improper welding leads to base metal damage weld on Skirt Plate ESD1-A65 B/B-4 Jt No#15. This weld has been VT, MT previously tested and accepted by ZPMC Quality Control personnel. Incident report for the same has been raised.

Out Side Yard:-

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Tower façade cover assembly Plate. The weld designations reviewed are as follows:-

ED1-SA35-09, 11, 35, 38, 57, 68, 71

IN PROCESS INSPECTION:-

BAY #10:-

This QA inspector observed the following work in progress:

SAW welding of weld joint no: ND1-SA3-16-109M-1-1A located on Angle Plate. Welder is identified as 052917. ZPMC QC is identified as Mr. Chen Ying Xin. The welding variables recorded by QC appeared to comply with the WPS-B-T-3221-TC-U5-S-1.

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: SSD1-SPSA4-24-4A located on Interior Splice Plate. Welder is identified as 040533. ZPMC QC is identified as Mr. Gang Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-A6002-14-38 located on Strut Plate. Welder is identified as 066155. ZPMC QC is identified as Mr. Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-4113-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: ND1-A6002-12-37 located on Strut Plate. Welder is identified as 040333. ZPMC QC is identified as Mr. Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113.

BAY #11:-

This QA inspector observed the following work in progress:

FCAW welding of weld joint no: ESD1-SPSA4-2-1B located on Interior Splice Plate. Welder is identified as 040775. ZPMC QC is identified as Mr. Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WD1-STSA3-2-99M-1-10A located on Strut Plate. Welder is identified as 046704. ZPMC QC is identified as Mrs. Yu Dong Ping. The welding variables recorded by QC appeared to comply

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with the WPS-B-T-3212-TC-U5b-1.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: WSTL4-2K/L-139 located on Skin C to Diaphragm. Welder is identified as 040675.ZPMC QC is identified as Mr. Le Hong Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-4314-TC-P5-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

The incident report is issued for the above mentioned discrepancy observed in Tower, Bay#11 Skirt plate and prior to issue it was informed to ZPMC QC and ABF QA.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge,Sinevod-13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Pandaram	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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